

Work Order ID 48152B

October 13, 2009 1:15:01 PM



Page 1

Item ID: D3186-4

Accept

Revision ID: D

Item Name: Spacepod Door, RH

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 09/10/13 Tooling:

Date:

Setup Start



Stop



QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3186

Rev B

100



Small Fab

Small Fab

Memo

0.00

0.00

BT 09-10-19

Small Fab

I-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

⇒ S 09/10/19

④

f

120



Packaging

Packaging

Identify as per dwg & Stock Location: PPP

0.00

Memo

PPP
t8/10/2

0.00

PC 09/10/21 C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 48152B

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Page 2

Item ID: D3186-4

Accept



Setup Start



Revision ID: D

Stop



Item Name: Spacepod Door, RH

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

130

QC21- Final Inspection - Work Order Release



QC

Quality Control

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

09/10/21 AD

MF 09-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 13, 2009 1:15:00 PM

Page 1

Work Order ID: 48152B



Parent Item: D3186-4RevD



Parent Item Name: Spacepod Door, RH

Start Date: 7/15/09

Required Date: 8/03/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3186-2MRevD



Manufactured

No

100

Each

0.0000

1.0000



SPACEPOD DOOR RH

48152B 01 2009-10-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:45:04 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACEPOD DOOR RH		
Job Number	: 48152B					
Estimate Number	: 12636					
P.O. Number	:			Part Number	: D31864	
This Issue	22/05/2009	S.O. No.	:	Drawing Number	: D3186 REV.D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	11	Type	SMALL /MED FAB	Drawing Revision	: D	
Previous Run	: 47002B			Material	:	
Written By	:			Due Date	: 12/06/2009	
Checked & Approved By	: JD 09.05.25			Qty:	1	Um: Each
Comment	: Est Rev:A New Issue 07-01-11 EC est rev.B revD 07.03.07 ec					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	✓ 48152B01	SPACEPOD DOOR RH	
2.0	✓ SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
3.0	✓ QC5	INSPECT WORK TO CURRENT STEP	
4.0	✓ PACKAGING 1	PACKAGING RESOURCE #1	
5.0	✓ QC21	FINAL INSPECTION/W/O RELEASE	
Job Completion			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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WORK ORDER

NO. ~~45153~~ 0209110114

Technical drawing of a mechanical part with the following dimensions and details:

- Width: 20.25
- Width of the base: 4.70
- Height: 1.80
- Width of the base: 5.50
- Width of the base: 3.46
- Angle: 15°
- Height: 1.10 TYP
- Detail B6-5: SEE DETAIL C 2 PL (top left)
- Detail A4-5: SEE DETAIL D 3 PL (top right)

D3186-1 SPACEPOD DOOR, LH

MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

Technical drawing showing a component with the following dimensions and references:

- Width: 3.59
- Height: 1.80
- Depth: 5.85
- Width of the main body: 1.41
- Width of the left side: 12.45
- Width of the bottom section: 5.50
- Width of the right side: 2.78
- Angle: 19°
- Width of the bottom right section: 1.24
- Reference A4-5: SEE DETAIL D
- Reference B6-5: SEE DETAIL C
- Reference C2-5: SEE DETAIL E
- Text: 2 PL
- Text: 1.10 TVP
- Text: E

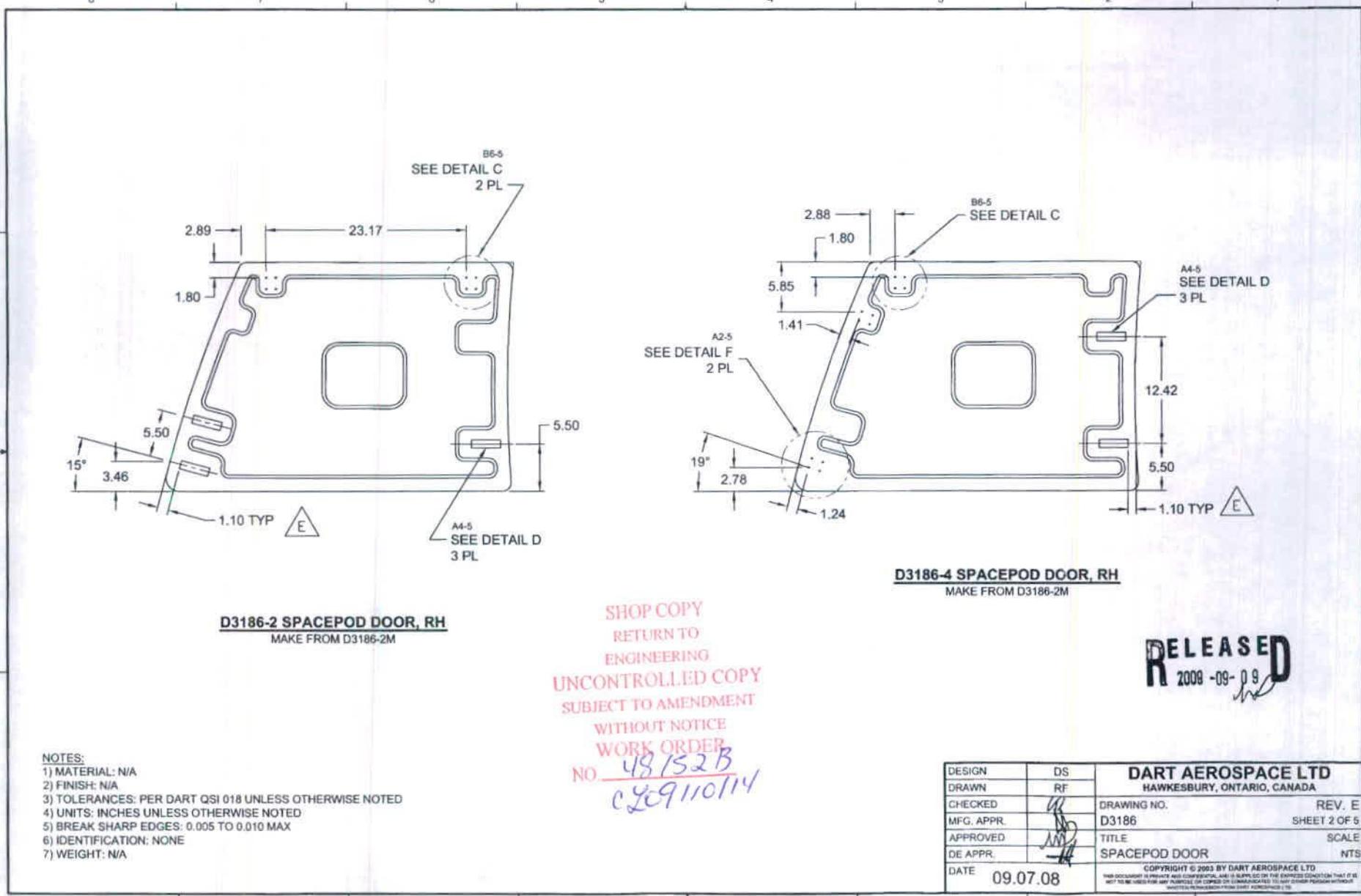
D3186-3 SPACEPOD DOOR, LH

RELEASED
2009-09-09
JW

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026		RF	09.07.08
D	UPDATE DIMENSIONS		LE	07.02.22
C	REMOVED D0600-XXX LABELS		LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M-/2M/-3/-4 ADDED		LE	06.09.25
A	NEW ISSUE		CP	03.03.27
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF	DRAWING NO.	REV. E	
CHECKED	<i>IP</i>	D3186	SHEET 1 OF 5	
MFG. APPR.	<i>IP</i>	TITLE		SCALE
APPROVED	<i>IP</i>	SPACEPOD DOOR		NTS
DE APPR.	<i>IP</i>			
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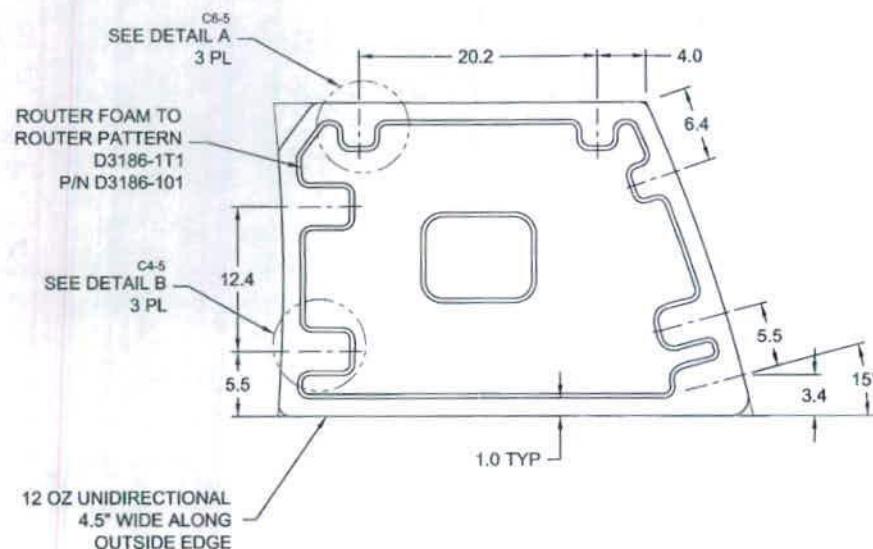


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D3186-1M SPACEPOD DOOR AS MOLDEDNOTES:

- 1) MATERIAL:
RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINCELL OR AIREX OR KLEGECCELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8005 FOR DOOR LAYUP

MAIN LAYUP
9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED
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MFG. APPR.	<i>BR</i>	D3186	SHEET 3 OF 5
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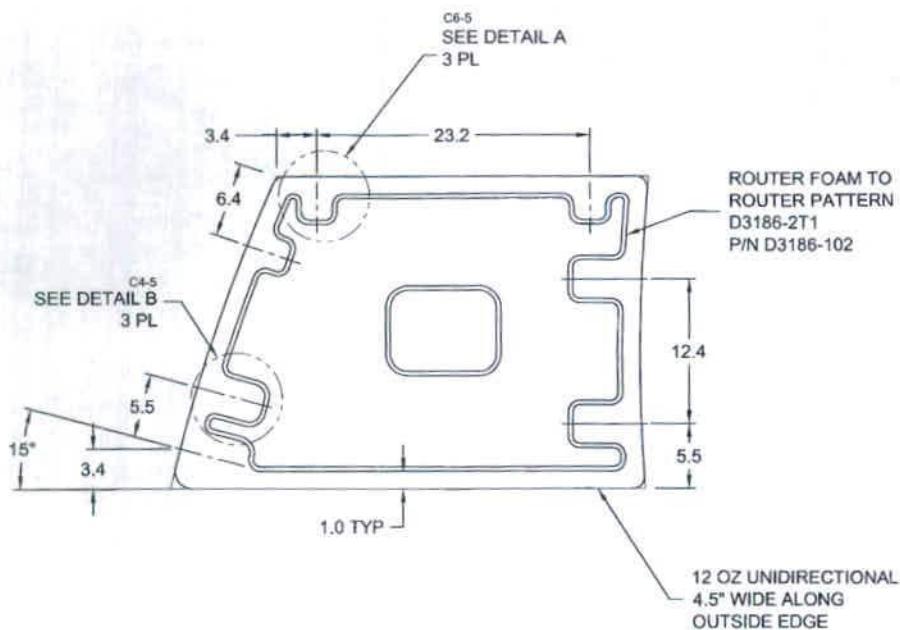
B

A



MAIN LAYUP
 9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY

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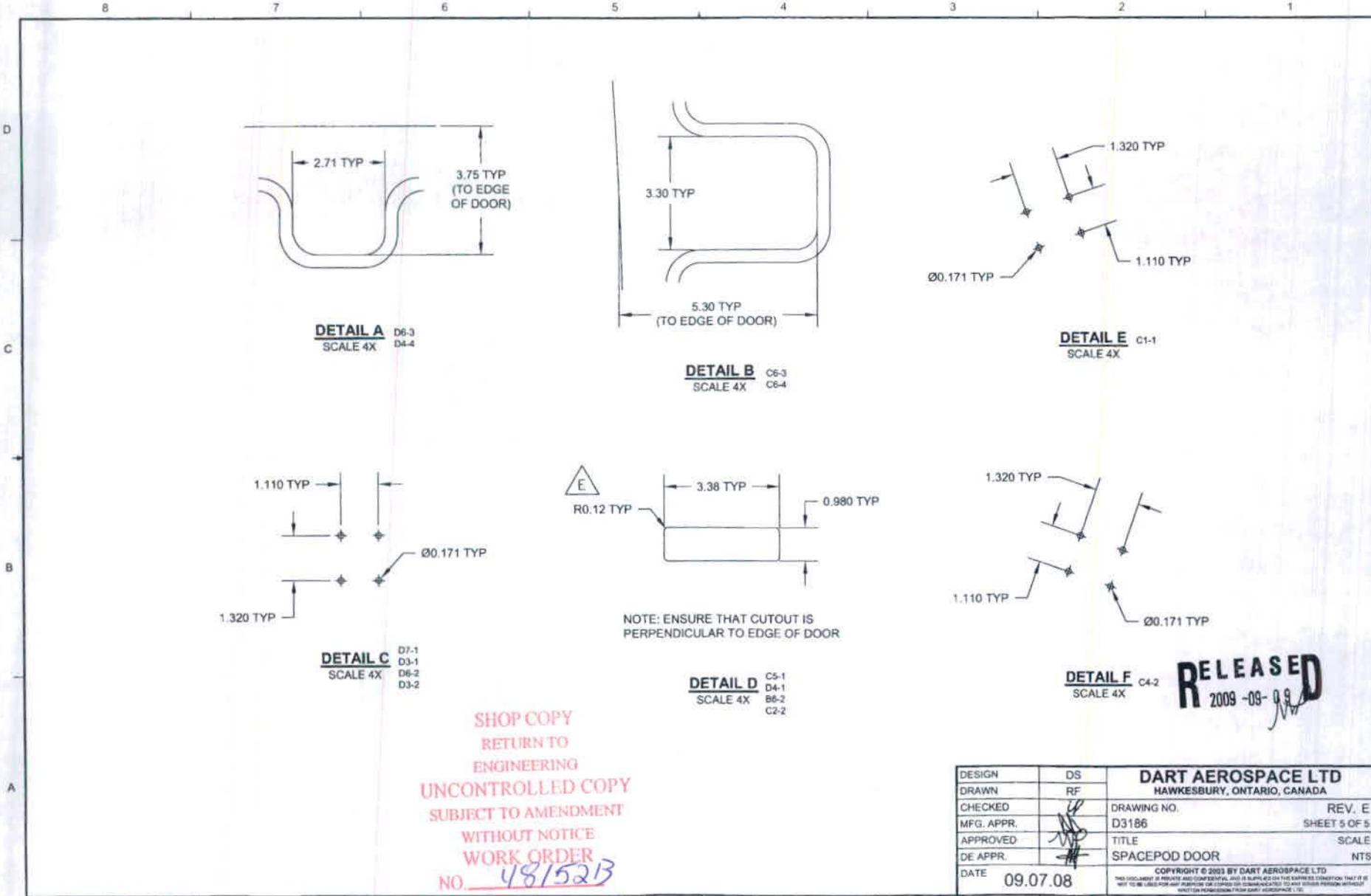
D3186-2M SPACEPOD DOOR AS MOLDED

NOTES:

- 1) MATERIAL:
 RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINCELL OR AIREX OR KLEGECCELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8006 FOR DOOR LAYUP

RELEASED
 2009-09-09
[Signature]

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MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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